

Work Order ID 53346

November 02, 2009 9:16:38 AM



RUSH

Page 1

Item ID: D3785-3 Accept

Revision ID: ~~A~~ C + HAND NEW UPS 10/21/02

Item Name: Bracket

Start Date: 11/2/2009 Start Qty: 3.00

Required Date: 11/4/2009 Req'd Qty: 3.00

Reference:

Approvals: Process Plan: MF Date: 09-10-02 Tooling: Date:

QC: Date: SPC (Y/N): Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3785	Rev C

100 0.00



Waterjet
FLOW CNC Waterjet

FLOW WATER JET

Memo

1-Cut as per Dwg D3785 Dwg Rev: C Prog Rev: C

□

****grain direction along 3.44****

□2- Deburr if necessary

189-11-2

③

110 0.00



QC
Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

189-11-2

120 0.00



QC
Quality Control

QC8- Inspect parts - second check

Memo

ENGINEERING
APPROVAL

Sosulce / [Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3785-3

Accept

Revision ID: R C + HAND MADE US 10/11/02



Setup Start



Item Name: Bracket

Stop



Start Date: 11/2/2009 Start Qty: 3.00



Cust Item ID:

Required Date: 11/4/2009 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



NC BRAKE

0.00

Brake NC

Memo

0.00

Brake NC

Bend as per Dwg D3785

Sp 09/11/03 ~~10/11/05~~

140



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

ENGINEERING
APPROVAL

10/11/03

150



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

1-counter sink holes as per dwg D3785

Ep 09/11/03 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3785-3

Accept



Setup Start



Revision ID:

B-4 Hand Make Up

Hand Make Up

Item Name:

Bracket

Stop



Start Date:

11/2/2009

Start Qty: 3.00



Cust Item ID:

Required Date:

11/4/2009

Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

2) Sculpts

(X3)

Quality Control

170

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

mo 09/11/03

X3

Hand Finishing

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

11 09/11/03

(X3)

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3785-3

Accept

Revision ID:

B-C + HAND MAKE UPS 10/11/02

Item Name:

Bracket

Start Date:

11/2/2009

Start Qty: 3.00

Required Date: 11/4/2009

Req'd Qty: 3.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

10:30

OVEN TEMPERATURE:

FINISH TIME:

320

200

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

210

Identify as per dwg & Stock Location: CA

0.00



Packaging

Memo

0.00

Packaging

Work Order ID 53346

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Page 5

Item ID: D3785-3

Revision ID: B

Item Name: Bracket

Start Date: 11/2/2009 Start Qty: 3.00

Required Date: 11/4/2009 Req'd Qty: 3.00

Reference:

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/03
WF 09-11-03

Picklist Print

November 02, 2009 9:16:37 AM

Page 1

Work Order ID: 53346

Parent Item: D3785-3RexB

Parent Item Name: Bracket

Comments:

Start Date: 11/2/2009

Required Date: 11/4/2009

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M6061T6S.080

Purchased

No

sf

267.4347

0.8100

25



B9-10-2

6061-T6 .080 Sheet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

267.4347

107904

0.02

110254

2.5

110630

38.0926

112040

0.0437

112141

33

112512

16.2784

112763

177.5

110254

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: C3346
Description: BRACKET		Part Number: D3785-3
Inspection Dwg: D3785-3 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .201	+ .005 - .001	.204	✓			
Ø .88	+ .010 - .001	.876	✓			
.405	± .010	.408	✓			
.75	± .030	.747	✓			
2.006	± .010	2.004	✓			
6.750	± .010	6.754	✓			
8.500	± .010	8.504	✓			
9.992	± .010	9.999	✓			
.73	± .030	.732	✓			
1.255	± .010	1.256	✓			
1.435	± .010	1.433	✓			
2.259	± .010	2.258	✓			
3.134	± .010	3.136	✓			
3.51	± .030	3.512	✓			
1.500	± .010	1.500	✓			
5.500	± .010	5.503	✓			
1.080	± .010	.076	✓			
Ø .391	± .006 - .001	.392	✓			

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 9-16-2	Date: 9/16/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

